

Wire and Welding products

HAYNES
Wire Company



HAYNES® 825 RTW™ Filler Metal

Product Description:

HAYNES® 825 RTW™ filler metal is used for gas metal arc and gas tungsten arc welding of alloy 825 and other alloys of similar composition. The weld metal is often used as a corrosion-resistant overlay on carbon and low alloy steels. The corrosion-resistant overlay performs well in oil and gas applications as well as reducing environments like sulphuric and phosphoric acids. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiFeCr-1 UNS N08065
ASME SFA-5.14 ERNiFeCr-1 ASME IX, F-No.45

Weld Deposit Chemistry:

Ni+Co	38.0 - 46.0	Si	0.50 max.
Cr	19.5 - 23.5	Other	0.50 max.
Fe	22.0 min.	Al	0.20 max.
Mo	2.5 - 3.5	S	0.03 max.
Cu	1.5 - 3.0	P	0.03 max.
Ti	0.6 - 1.2	C	0.05 max.
Mn	1.0 max.		

Minimum Mechanical Properties:

Tensile (psi) 80,000
Mpa 552
Elongation (%) 25

Available Product Forms:

Diameter, in.	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter, mm.	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.
Straight lengths are available in 36" lengths.

HW-7034C

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